

Date: Thursday, 10/18/2007 7:40:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE BRACKET
Job Number	: 35164		
Estimate Number	: 12256		
P.O. Number	:	Part Number	: D3481041
This Issue	: 10/18/2007 S.O. No. :	Drawing Number	: D3481 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 28532	Material	:
Written By	:	Due Date	: 10/31/2007
Checked & Approved By	: <u>07.10.18</u>	Qty:	5 Um: Each
Comment	: Est Rev: A New Issue 06-02-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D3481043	bracket & clamp ass'y
-----	----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3481-3043	Bracket Assembly	35192

2.0	BACN10YD3	CLIP FLOATING NUT
-----	-----------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	BACN10YD3	Clip	M100977

3.0	AN33A	Bolt
-----	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-3A	Bolt	M104547

4.0	AN96010	Washer
-----	---------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-10	Washer	M5519

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:40:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE BRACKET

Job Number: 35164

Part Number: D3481041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34811

ANGLE BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3481-1 Bracket

334406

07/11/05

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

07/11/05 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/05 (25) counter

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a fine point permanent marker and Stock

Location: ST. 104

AS 07/11/06

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



07.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

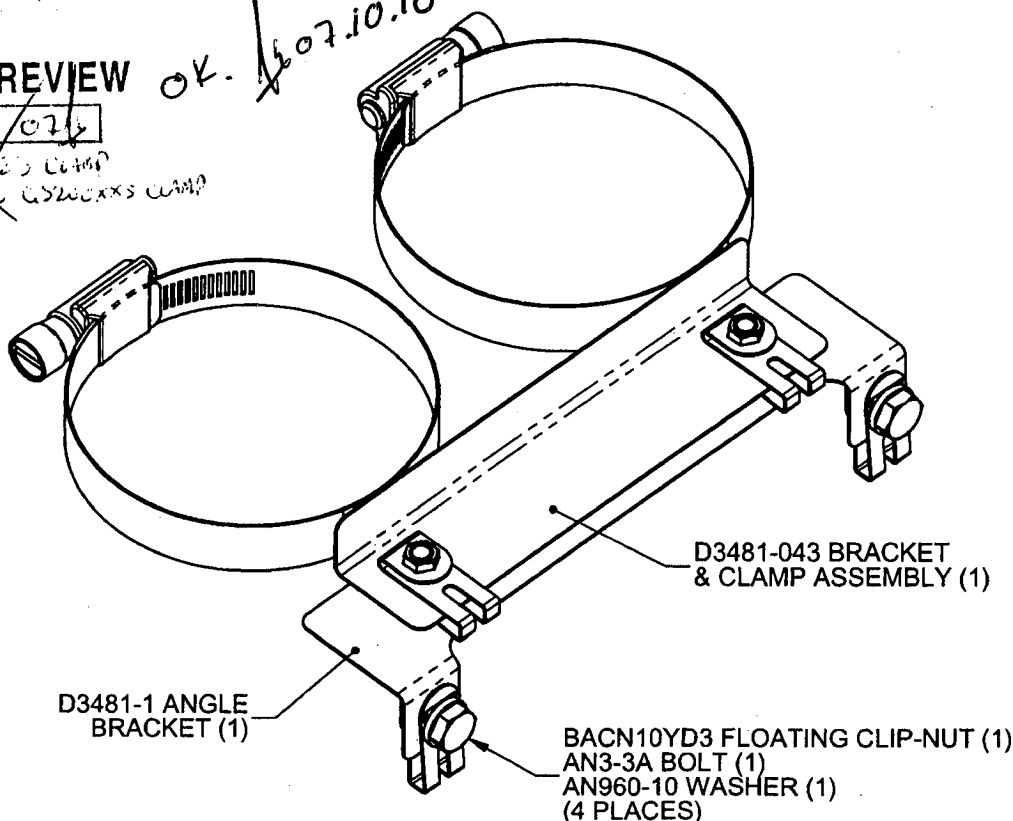


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	

06.04.03
UNDER REVIEW

07.09.07

*Q5200005 CLAMP
CHANGED TO Q5200005 CLAMP*



D3481-041 SHUT-OFF VALVE BRACKET

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

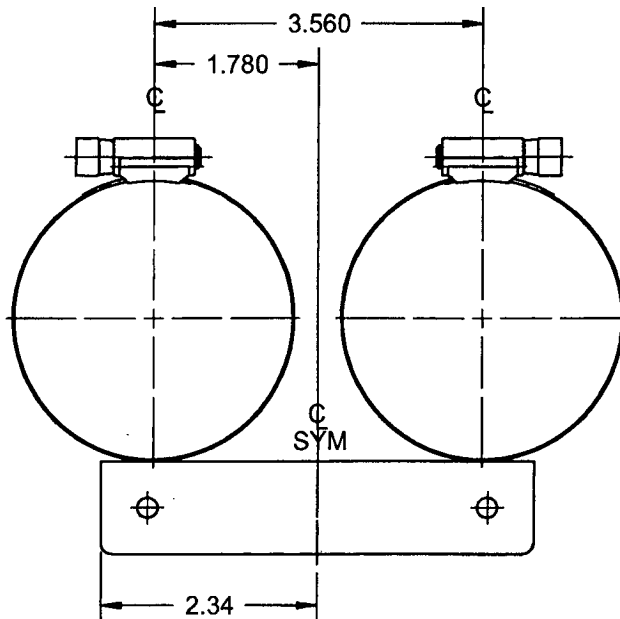
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *35164*

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 2 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

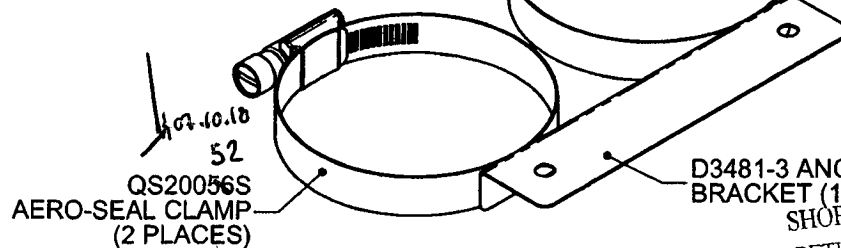
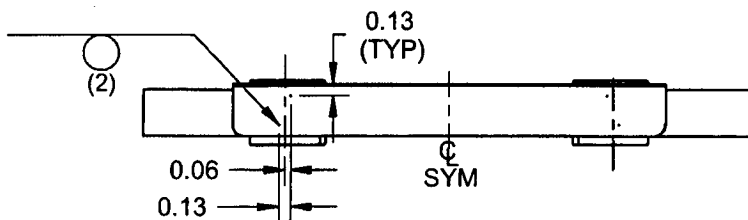


[Signature] 06-04-03



UNDER REVIEW

07-07-07
QS20056S CLAMP
CHANGED TO QS20056S CLAMP



D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

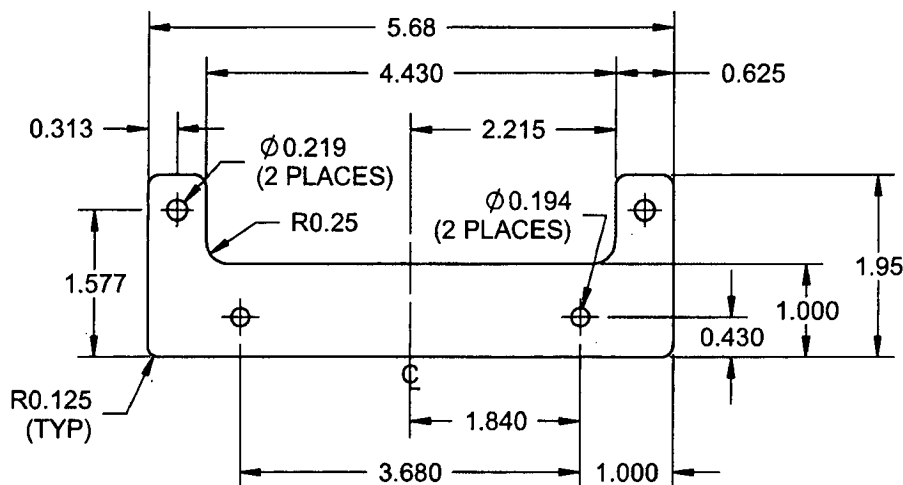
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER *35164*

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

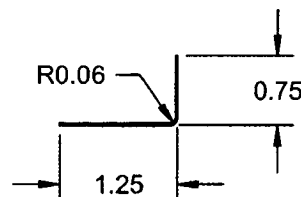
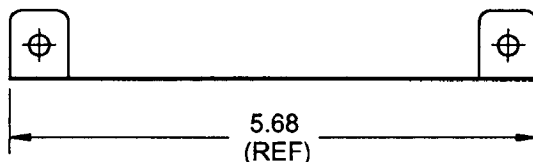
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 3 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-1F FLAT PATTERN

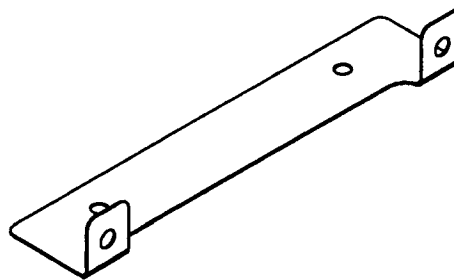


D3481-1 ANGLE BRACKET

[Handwritten signature] 06.04.03

UNDER REVIEW

07.09.02
Q520070'S COMP
CHANGED TO Q5200XXS COMP



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35164

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



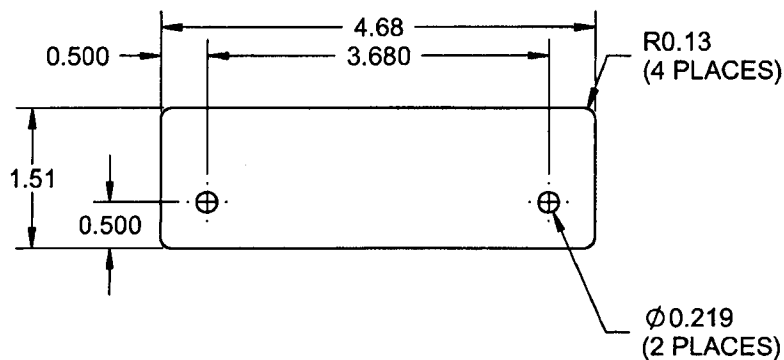
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

UNDER REVIEW

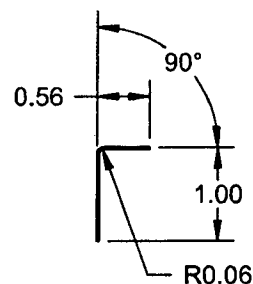
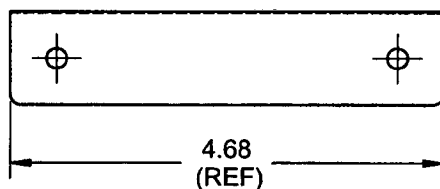
07.09.02

06.04.03

Q520025 COMP
CHANGED TO Q5200XXS COMP



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35164

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.